

Work Order ID 160652

Tuesday, May 02, 2017 2:54:16 PM

160652

Page 1

Item ID: D2001-4

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Valve Assembly 1/4 inch

Start Date: 5/3/2017 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/11/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: DAS 13 9-89 Date: MAY 02 2017 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

NR1

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2001	Rev C								
100	PURCHASING	0.00							DAS 13 9-89
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: <u>36226</u>								
	P/N: 76-101-32 (1/4 NPT)								
	Possible Supplier: Flo-Control Inc.								
	Material release note is required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							DAS 6 9-89
110									
Packaging	Memo	0.08							
Packaging	Ensure Material Release Note is attached								
120	QC6- All purchased or subcontracted products	0.00							DAS 38 9-89
120									
QC	Memo	0.00							
Quality Control									

MAY 19 2017

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Item ID: D2001-4

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N900040100

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NS1

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Stop

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Start Date: 5/3/2017 Start Qty: 4.00

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Cust Item ID:

Required Date: 5/11/2017 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

130

Small Fab

Small Fab

0.00

Memo

0.31

Small Fab

Remove existing ID numbers and replace with Dart P/N & B/N

4X

17/05/19

D
3
9-1

140

140

QC

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.08

Quality Control

4

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38
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MAY 19 2017

150

150

Packaging

Identify as per dwg & Stock Location:

Stool

0.00

Memo

0.04

Packaging

4

DAS
6
9-89

MAY 24 2017

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Item ID: D2001-4**Accept*****N900040100*****Setup Start *NS1*****Revision ID:****Stop *NS2*****Item Name:** Valve Assembly 1/4 inch**Start Date:** 5/3/2017 **Start Qty:** 4.00 ***4*****Cust Item ID:****Required Date:** 5/11/2017 **Req'd Qty:** 4.00 ***4*****Customer:****Reference:****Approvals:** **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____**Run Start *NR1*****QC:** _____ **Date:** _____ **SPC (Y/N):** _____ **Date:** _____**Stop *NR2*****Sequence ID/
Work Center ID****Operation
Description****Set Up/
Run Hours****Tool ID****Tool #****Plan
Code****Accept
Qty****Reject
Qty****Reject
Number****Insp.
Stamp**

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.40

Quality Control

17/5/25
MAY 24 2017

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		☐ OTHER : _____							

Picklist Print

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Work Order ID: 160652

160652

Parent Item: D2001-4

D2001-4

Parent Item Name: Valve Assembly 1/4 inch

Start Date: 5/3/2017

Required Date: 5/11/2017

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A04.07.06New IssueKJ/RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
76-101-32		Purchased	No			110	Each	0.0000	1	4			
76-101-32									**				
VALVE													

DAS
6
5-80

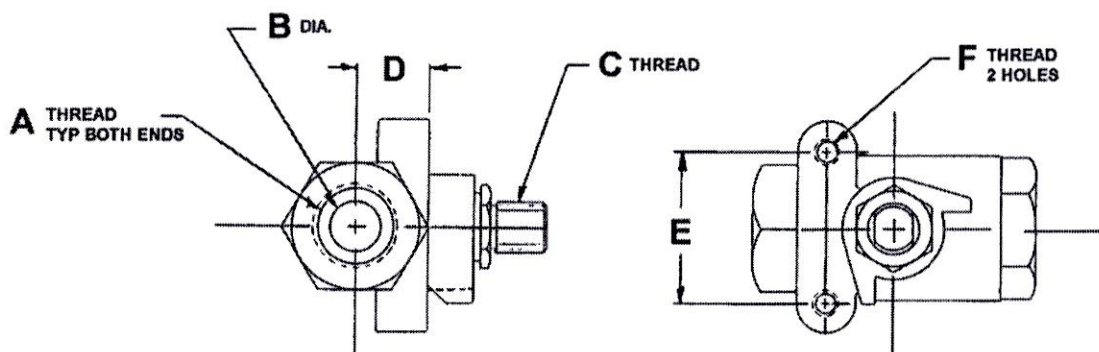
MAY 18 2017



DESIGN RT	DRAWN BY RT	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2001	REV. C SHEET 1 OF 1
DATE 04.07.06		TITLE VALVE ASSEMBLY	SCALE NTS
-	90.04.02	NEW ISSUE	
A	92.05.12	-043 ADDED	
B	96.04.10	DART P/N CHG,041-6,042-12,ADD -16	
C	04.07.06	ADD D2001-4	

RELEASED
04.09.09

SPECIFICATION CONTROL DRAWING



Dart P/N	Apollo P/N	A	B	C	D	E	F
D2001-4	76-101-32	1/4 NPT	0.370	3/8-24 NF	0.56	1.120	10-24 UNC
D2001-6	76-102-01	3/8 NPT	0.370	3/8-24 NF	0.56	1.120	10-24 UNC
D2001-8	76-103-01	1/2 NPT	0.500	3/8-24 NF	0.60	1.120	10-24 UNC
D2001-12	76-104-01	3/4 NPT	0.680	7/16-20 NF	0.79	1.370	10-24 UNC
D2001-16	76-105-01	1 NPT	0.870	7/16-20	0.99	1.370	10-24 UNC

NOTES:

- 1) POSSIBLE SUPPLIER: FLO-CONTROL INC. OR APOLLO VALVE DIVISION
- 2) DISCARD HANDLE AND ATTACHING NUT, EXCEPT FOR D2001-4
- 3) CHECK DIMENSION SHOWN ON THIS DRAWING
- 4) REFERENCE INFORMATION:

MATERIAL: 316 STAINLESS STEEL
INVESTMENT CAST COMPONENTS
MEETS NACE-MR-01-75
MEETS WW-V-35C TYPE II, COMP SS, STYLE 3
PRESSURE RATING: 2000 PSI @ 100°F
150 PSI @ 400°F

- 5) IDENTIFY WITH DART P/N & B/N USING FINE POINT PERMANENT INK MARKER

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W10:160652

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Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO36226**

Purchase Order Date 5/8/2017 10:37:39 AM

PO Print Date 5/8/2017

Page Number 1 of 1

Order From :

FLO-CONTROL INC.
80 CENTER RD.
CARTERSVILLE, GA 30121
US

VU-FL0001

Ship To : DART AEROSPACE LTD
1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

MAY 08 2017

Contact Name

Vendor Phone 770 382 0006

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Ship To Contact

Ship To Phone

Terms

Net 30

Ship Via:

FedEx Overnight collect

Currency

USD

Ship Acct:

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	76-101-32 AS PER DWG D2001 REV.C B160652	VALVE	5/15/2017 Yes 5/15/2017		4.00 Each	\$52.61	\$210.44
Line Total:							\$210.44
2	71401-45 Procurement Quality Clauses A005 right of entry A012 chemical and physical test report A016 personnel qualification A026 certification of material conformance A040 notification of quality escape A043 retention of quality documents	PROCUREMENT QUALITY CLAUSES	5/15/2017 No 5/15/2017		1.00	\$0.00	\$0.00
Line Total:							\$0.00
PO Total:							\$210.44

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9-89

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(20) CL

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 5/8/2017

CONBRACO INDUSTRIES, INC.
701 MATTHEWS MINT HILL RD.
MATTHEWS, NC 28105
(704) 847-9191



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Plt(s) STC Pcs

Sold to:		Ship To:		** ORIGINAL **		
FLO-CONTROL INC 80 CENTER RD CARTERSVILLE GA 30121 UNITED STATES		DART AEROSPACE 12070 ABERDEEN PO#P036226 HAWKESBURY CANADA ON K6A1K7		Pieces: 1 Weight: 2.70 PPD/COL: C Packed By: JAMES P Pack Date: 5/11/17 Shipped By: SHIPPRF Ship Date: 5/11/17 PRO# ASN# 67075000017628003		
Cust Nbr. 01004667	Cust Order# 76063	Order Nbr. C808988	Date Received: 5/10/17	Salesman: 2	Ship Via/Instructions: FX01 151793240	
Line Number	Part Number	Part Description	Quantity Ordered	Quantity Shipped	Unit	Customer Part Number / Comments
1000	7610132A	BV, 1/4"NPT, SS, SS TEE HNDL SHIPPING LOCATION:	4	4	EA	DAS 6 9-89 38 9-89

PACKING SLIP